

# Work Order ID 60968

Tuesday, August 03, 2010 8:59:54 AM

Page 1

Item ID: D4019-041

Accept

Setup Start

Stop

Revision ID:

Item Name: Light Lid Short Basket Assembly

Start Date: 8/4/2010 Start Qty: 1.00

Required Date: 8/10/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals: Process Plan: mf Date: 10-8-03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D4019 C

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: M112860 0.00  
Large Fab

0.00

## Memo

1- Assemble ribs, weld as per dwg D4019 using DT9606B. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

\*\*\*\*DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME\*\*\*\*

2- weld hinge, label plate and Mounting plates as per dwg D4019

QC9- Inspect visual per QS1004- Fusion Welds 0.00

110



QC

Quality Control

## Memo

0.00

10.08.03

BE

10/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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120 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(H)			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***	0.00 0.00							
140 Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <del>M112880</del>  Memo 1- weld (4) corners	0.00 0.00							

8/10/10

⇒ H 10/08/10

YI Ø

10-08-10

1 Ø

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PD 10.08.10

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

- ✓ 1- touch up corner with alodine only  
✓ 2- Plug holes prior to and mask sides of hinge prior to powdercoat

=7 JJ 10/08/10

1 d

1ST COAT:

START TIME: 10:50AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:20AM

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: / N/A

OVEN TEMPERATURE: /

FINISH TIME: /

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170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							<i>8/5/08/10 @</i>
180  HandFinish Hand Finishing	Assemble as per dwg  Memo Install webbing as per dwg and label	0.00  0.00							<i>8/5/08/10 @</i>
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							<i>8/10/08/10</i> 

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Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

*EP 2/08/10 @*

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/08/11 AD**W.O.S.H*

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Parent Item: D4019-041

Parent Item Name: Light Lid Short Basket Assembly



Start Date: 8/4/2010

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Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.07 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
DD 10.04.20 verified by:EC  
IPP Rev:B as  
IPP Rev:C as per dwg revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-243  Placard, Max Load		Manufactured	No			180	Each	10.0000	1	1		8/5/10/08/10	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST112				10					
				56981				10					
MS20600-AD4W3  Cherry Rivets		Purchased	No			180	Each	1,619.000	30	30		8/5/10/08/10	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST321				1619					
				106375				3					
				107939				822					
				111636				794					
D4019-1  Rib		Manufactured	No			100	Each	0.0000	2	2		8/6/09/4 -> 2 PD 10.08.06	
D4019-3  Rib		Manufactured	No			100	Each	9.0000	2	2		PD 10.08.06	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				9				2	
				58386				3					
				59745				6					

W/O:		WORK ORDER CHANGES					
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Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

D4016-5

Manufactured No

100

Each

18.0000

3

3



Hinge Half, Light Lid

Location

Loc Qty

Loc Code

ENG

2

56075

2

ST116

10

58304

10

WA

6

58592

6

100

Each

19.0000

4

4



PD 10.08.06

D2957

Manufactured No



Mounting Plate

Location

Loc Qty

Loc Code

WA

19

57697

1

58302

12

58593

6

100

Each

3.0000

1

1



PD 10.08.06

D4035-045

Manufactured No



Lid Rib Assembly, Fwd (Light)

Location

Loc Qty

Loc Code

WA

3

58378

1

59733

2

①

PD 10.08.06

Tuesday, August 03, 2010 8:59:53 AM

Shop Packet Print

Page 2

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Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

D4035-047

Manufactured No

100 Each

3.0000

1 1



Lid Rib Assembly, Aft (Light)

LocationLoc QtyLoc Code

WA

3

58377

1

59734

2

180 Each

6.0000

1

D4029-043

Manufactured No



Webbing (Short Basket)

LocationLoc QtyLoc Code

st503

6

56967

6

100 Each

13.0000

1

D4056-1

Manufactured No



Label Plate

LocationLoc QtyLoc Code

WA

13

58308

9

58583

2

59750

2

Tuesday, August 03, 2010 8:59:53 AM

Shop Packet Print

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Start Date: 8/4/2010

Required Date: 8/10/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN416J

Purchased

No

180

Each

532.0000

30

30



Washer



8/5/10/08/10

## Location

## Loc Qty

## Loc Code

ST		4
13910		4
ST275		132
114340		132
ST298		396
114348		52
114597		344

30

Tuesday, August 03, 2010 8:59:53 AM

Shop Packet Print

Page 4

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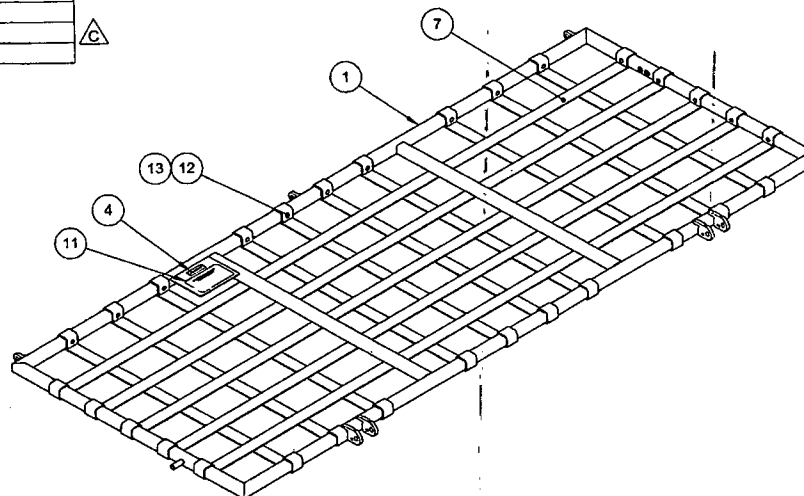
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	X	D4019-101	BASKET LID WELDMENT
2		2	D4019-1	RIB
3		2	D4019-3	RIB
4	1		D2728-1	DART LOGO LABEL
5		4	D2957	MOUNTING PLATE
6		3	D4016-5	HINGE HALF
7	1		D4029-043	WEBBING (SHORT BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-243	PLACARD, MAX LOAD
12	30		MS20600AD4W3	BLIND RIVET
13	30		NAS1149DN416J	WASHER



**D4019-041 LIGHT LID SHORT BASKET ASSY**

**RELEASED**  
2010-04-14

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.83 lbs

C	MS20600AD4W3 WAS MS20600AD4WS: BOM & (B3-2)	JPH	10.04.06
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4086-243 PLACARD AS ITEM 11. ITEMS RENUMBERED AS REQD. DETAIL E ADDED (A7-2) & (D5-2). SECTION B-B REV'D (D6-3) DIM ADDED (B4-3). WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4019	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LIGHT LID SHORT BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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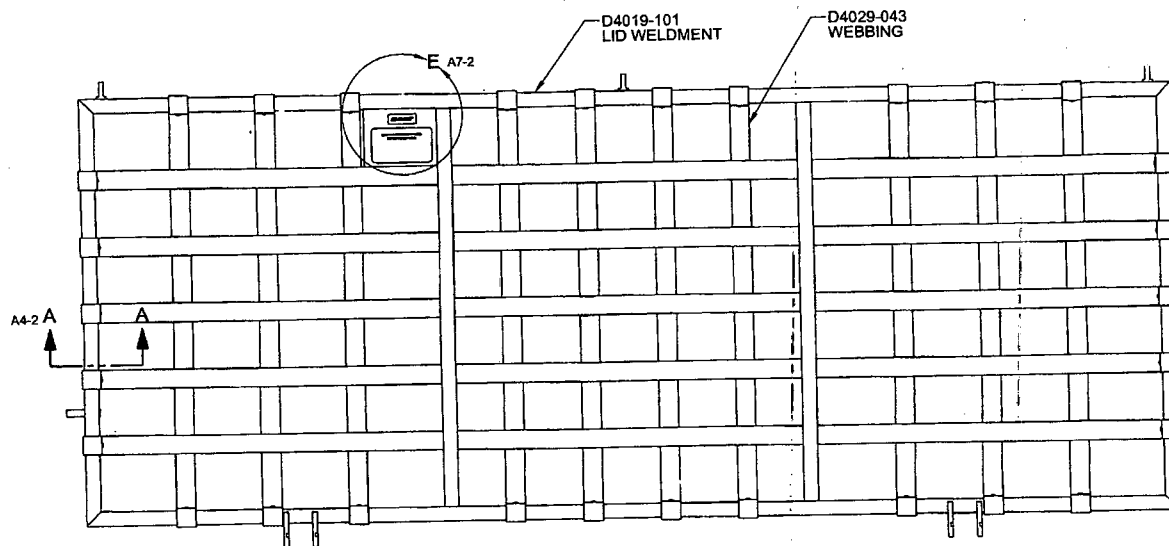
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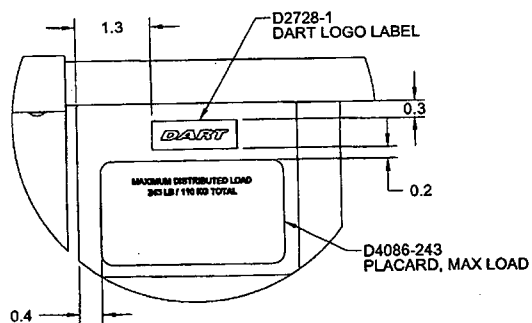
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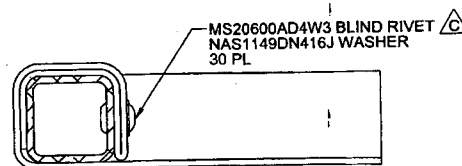
#60968



**D4019-041 LIGHT LID SHORT BASKET ASSY**



**DETAIL E D5-2**



**SECTION A-A C7-2**

**RELEASED**  
2010-04-14

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4019	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>LIGHT LID SHORT BASKET</b>	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

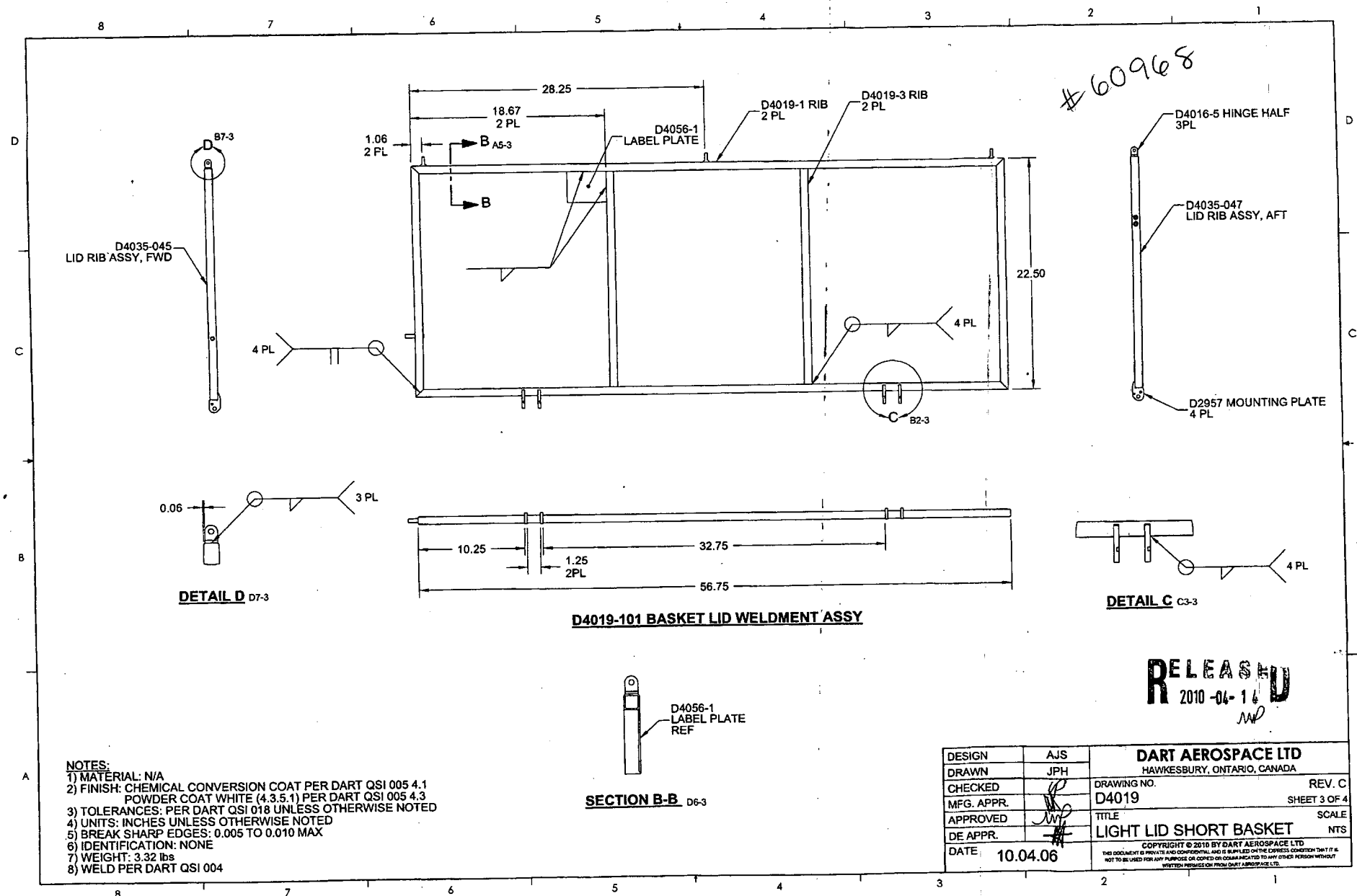
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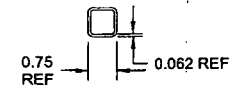
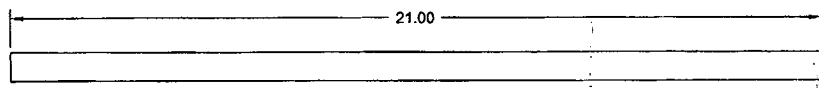
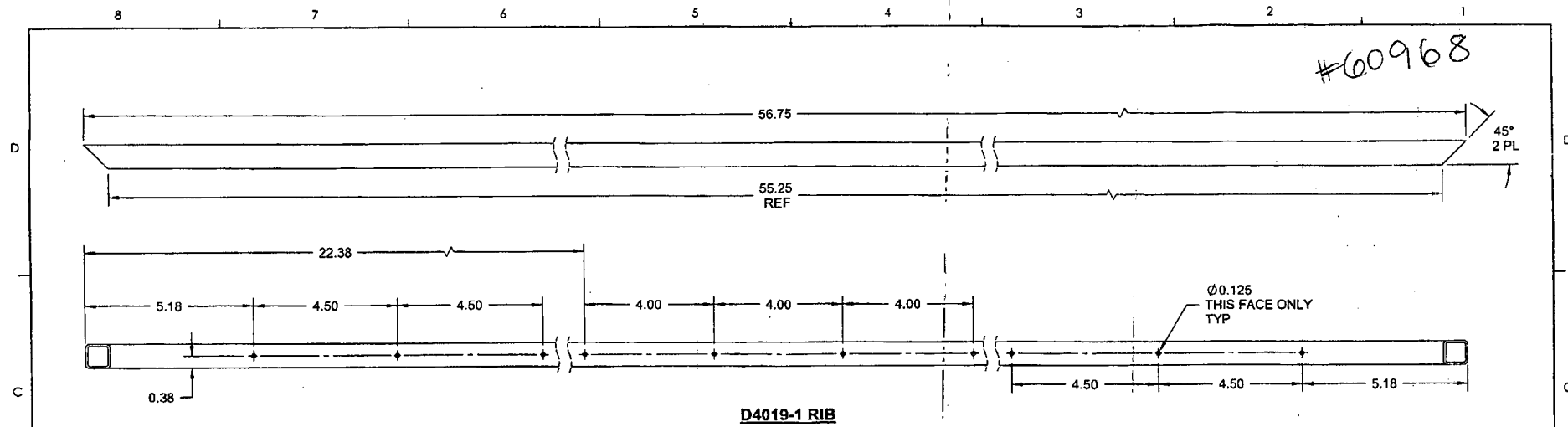
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#60968



RELEASED  
2010-04-14  
NWP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs  
-3: 0.77 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4019	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID SHORT BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries